

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006422**Date Inspected:** 30-Apr-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Zhi jiang/ Li Xin Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components/ Tower Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Hiranch Patel, was present during the times noted above for observations relative to the work being performed.

**Bay #3**

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member is identified as OBG Components. The weld designations reviewed are as follows:

-(FB003-144-105/104)

**Bay #2**

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member is identified as OBG Components. The weld designations reviewed are as follows:

-(Seg1E- 587, 588)

**Bay #11**

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member is identified as Tower Components. The weld designations reviewed are as follows:

-(WSD1-FDSA3-2B/C-52A/B)

-(WSD1-FDSA3-2B/C-28A/B)

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

-(WSD1-FDSA3-2B/C-31A/B)  
-(WSD1-FDSA3-2B/C-32A/B)  
-(WSD1-FDSA3-2B/C-33A/B)  
-(WSD1-FDSA3-2B/C-50A/B)  
-(WSD1-FDSA3-2B/C-21A/B)  
-(WSD1-FDSA3-2B/C-24A/B)  
-(WSD1-FDSA3-2B/C-25A/B)  
-(WSD1-FDSA3-2B/C-26A/B)  
-(WSD1-FCSA3-2B/C-63A/B)  
-(WSD1-FCSA3-2B/C-64A/B)  
-(WSD1-FCSA3-2B/C-65A/B)  
-(WSD1-FCSA3-2B/C-66A/B)  
-(WSD1-FCSA3-2B/C-53A/B)  
-(WSD1-FCSA3-2B/C-54A/B)  
-(WSD1-FCSA3-2B/C-55A/B)  
-(WSD1-FCSA3-2B/C-56A/B) 4 mm Linear Indication found, after grinding indication removed.  
Result- Weld accepted by ZPMC QC and CT.  
-(WSD1-FCSA3-2B/C-57A/B)  
-(WSD1-FCSA3-2B/C-44A)  
-(WSD1-FCSA3-2B/C-45A/B)  
-(WSD1-FCSA3-2B/C-46A/B)  
-(WSD1-FCSA3-2B/C-47A/B)  
-(WSD1-FCSA3-2B/C-48A/B)  
-(WSD1-FBSA3-2B/C-04A/B)  
-(WSD1-FDSA3-2B/C-05A/B)  
-(WSD1-FDSA3-2B/C-06A/B)

### 1AE

This Quality Assurance Inspector, Hiranch Patel, observed on Segment 1AE, during 300 mm end cutting, the SP402A, SP 408A and LD025-001 damaged during this cutting process. ZPMC QC and ABF were present at the time of this incident. This QA inspector generated an Incident report TL015 for this.

### Tower Lift 3

This Quality Assurance Inspector, Hiranch Patel, found 7 mm long Linear Indication in Tower Lift 3 C3, Weld# WSD1-FCSA3-2B/C-62A/B during 10% Magnetic Particle Testing on the weld previously inspected and accepted by ZPMC QC. This QA inspector generated an Incident report TL015 for this.

Unless otherwise noted, all observed on this date appeared to generally comply with applicable contract documents

### Summary of Conversations:

No relevant conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or

---

## WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

---

remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

---

<b>Inspected By:</b>	Patel,Hiranch	Quality Assurance Inspector
<b>Reviewed By:</b>	Prue,Erik	QA Reviewer

---